

Shy April 12

Work Order ID 81566

81566

Page 1

March-15-12 12:45:45 PM

Item ID: D3267-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Basket lid Assembly (Outside)
 Start Date: 15/03/2012 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 13/04/2012 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: M.L.J. Date: 12/03/15 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3267	Rev C

100 Weld per dwg A/R S.S. rod Batch: #8366 0.00

100

Large Fab Memo 0.00

Large Fab 1-Cut Rib from 3/4" x 3/4" x 0.063" wall 304/316 SS tubing as per Dwg D3267

2-Cut (4) D2236-1 From D3166-3

3-Drill holes in tubing D3267-041 as per Dwg D3267

4-Deburr & Remove All Markings From Material

5-Weld D3267-041 Assembly using Welding Table and corner Jig as per Dwg D3267. Deburr as required
 Note: Expanded metal "diamonds" must run lengthwise. Eg 2.0" along length of lid.

6-Drill Ø0.257" hole in D3267-041 as per Dwg D3267 Identify as D3267-041

1x Ø 12.04.13

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Basket lid Assembly (Outside)

Start Date: 15/03/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 13/04/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

110

QC9- Inspect visual per QS1004- Fusion Welds

0.00

110

QC

Memo

0.00

Quality Control

MBK
12.04.15

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Authentic Memo

0.00

Quality Control

Sitzler

Dart Aerospace Ltd

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130 *130* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 1ST COAT START TIME: 10-20 OVEN TEMPERATURE: 400°F FINISH TIME: 10-50 ***** 2nd coat if necessary ***** 2ND COAT: START TIME: 11-00 OVEN TEMPERATURE: 400°F FINISH TIME: 11-30	0.00 0.00				IX			m-f 12/04/16
140 *140* HandFinish Hand Finishing	HandFinishing Memo Wing walk as per Dwg D3267 and QSI 005 4.4 Spray Paint Black: 1181191 Wing Walk: 120902	0.00 0.00				1			BL 12-4-16

121134

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--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150	QC3- Inspect Part Finish	0.00							
150									
QC	Memo	0.00							
Quality Control									

155	Identify as per dwg & Stock Location: <u>67A</u>	0.00							
155									
Packaging	Memo	0.00							
Packaging									

160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

Handwritten notes and signatures:
 12/04/16
 12/04/16
 12/4/17
 12-4-15

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Picklist Print

March-15-12 12:46:16 PM

Page 1

Work Order ID: 81566

81566

Parent Item: D3267-041

D3267-041

Parent Item Name: Basket lid Assembly (Outside)

Start Date: 15/03/2012

Required Date: 13/04/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:C Removed -043 05-11-04 JLM
 IPP Rev:D 08-09-10 revC as per dwg (ecn 08-524) DD verified by:EC
 IPP Rev:E add I.D. DD 10.03.11 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2327-3		Manufactured	No			100	Each	44.0000	2	2			
---------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

D2327-3

Spacer Bushing

**

SAD 12-04-05

Location

Loc Qty

Loc Code

WA

22

79333

22

WA005

22

75564

1

77229

1

81144

20

(2)

D2506		Manufactured	No			100	Each	9.0000	1	1			
-------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

D2506

Label Plate

**

SAD 12-04-05

Location

Loc Qty

Loc Code

WA006

9

79197

9

(2)

D2581		Manufactured	No			100	Each	27.0000	2	2			
-------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

D2581

Mounting Bracket

**

SAD 12-04-05

Location

Loc Qty

Loc Code

WA005

27

69739

1

70766

2

77045

1

77523

23

B81253 2

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 2

Work Order ID: 81566

81566

Parent Item: D3267-041

D3267-041

Parent Item Name: Basket lid Assembly (Outside)

Start Date: 15/03/2012

Required Date: 13/04/2012

Start Qty: 1.00

Required Qty: 1.00

D3166-3 Manufactured No

100 Each

3.0000 1 1

D3166-3

Basket Hoop

**

SAD 12-04-05

Location

Loc Qty

Loc Code

WA007

3

77294

3

M304EX0.75-16F

Purchased

No

100 sf

711.9496 7.8

8.210526

M304FX0 75-16F

Expanded Metal Flat SS

**

SAD 12-04-05

Location

Loc Qty

Loc Code

WA

0.0001156

119180

0.0001156

WA035

711.9494457

117197

102.9036

117896

29.49258

118153

76.8473

118955

82.17

119180

53.6958107

119729

28.1132686

120153

2.97557478

120318

39.8113116

120917

295.94

121

8.2106

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item Name: Basket lid Assembly (Outside)

81566

D3267-041

Start Date: 15/03/2012

Required Date: 13/04/2012

Start Qty: 1.00

Required Qty: 1.00

M304TS0.750W.065

Purchased

No

100

f

664.5479

30.6

32.21053

M304TS0 750W 065

304 SQ Tube .75x.75x.065W

**

SAD 12-04-05

Location

Loc Qty

Loc Code

MAT017

616.890429

120267

116.890429

120633

500

MAT018

41

7636

41

WA007

0.5907428

116763

0.5907428

WA035

6.0667

118181

6.0667

M121070

32.2106

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QTY -041	QTY -043	PART NUMBER	DESCRIPTION
X		D3267-041	BASKET LID ASSEMBLY (OUTSIDE)
	X	D3267-043	BASKET LID ASSEMBLY (INSIDE)
2		D2327-3	SPACER BUSHING
1		D2506	LABEL PLATE
1		D2512-7	STRUT
2		D2581	MOUNTING BRACKET
	1	D2989-1	STRUT
	1	D2989-2	STRUT
	1	D2989-3	STRUT
	1	D2989-4	STRUT
	2	D2989-5	STRUT
	2	D2989-7	STRUT
1		D2989-9	STRUT
1		D2989-10	STRUT
1		D2989-11	STRUT
1		D2989-12	STRUT
2		D2989-13	STRUT
2		D2989-15	STRUT
	2	D3182-1	HINGE
2	2	D3265-3	STRUT
1		D3266-7	STRUT
2		D3267-1	STRUT
	2	D3442-3	SHIM

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 81566 MCT

12/03/15

RELEASED
08-09-04-14



NOTES:

- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
(D2989-3/4/5/11/12/13 CAN BE MADE FROM D2236)
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
- 3) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3.
BLACK ANTI-SKID PAINT INDICATED AREA PER DART QSI 005 4.4.
SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004

C	DRAWING UPDATED TO CURRENT STANDARDS. SHEET 3 ADDED. FRAME MATERIAL WALL THICKNESS WAS 0.060. D3267-1 DETAILED.	AJS	08.08.15
B	ADD SHIM UNDER HINGES	PH	05.06.08
A	NEW ISSUE	DS	04.02.02
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>PH</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>PH</i>	D3267	SHEET 1 OF 3
APPROVED	<i>PH</i>	TITLE	SCALE
DE APPR.	<i>PH</i>	BASKET LID ASSEMBLY	NTS
DATE	08.08.15	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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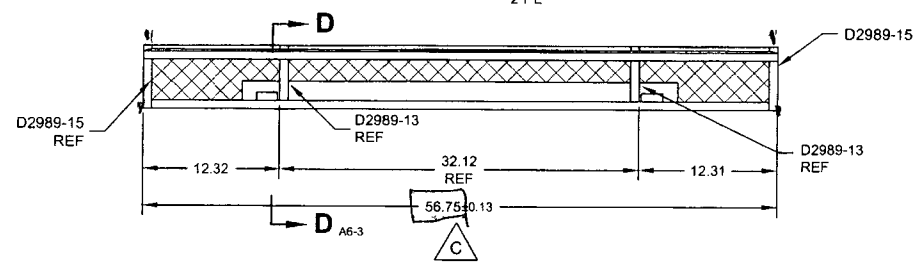
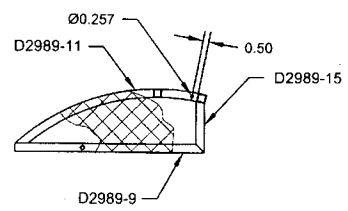
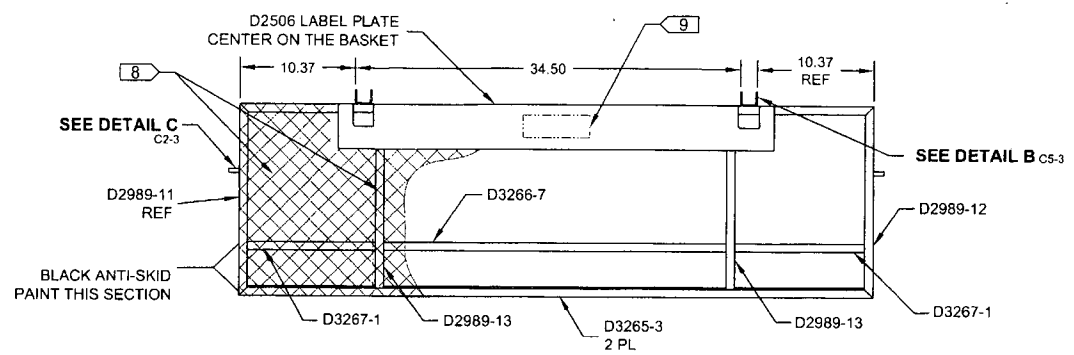
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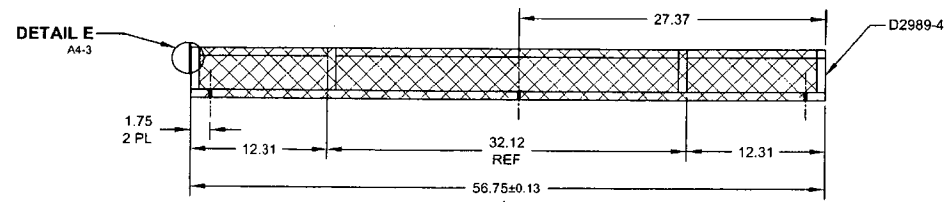
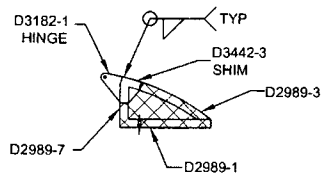
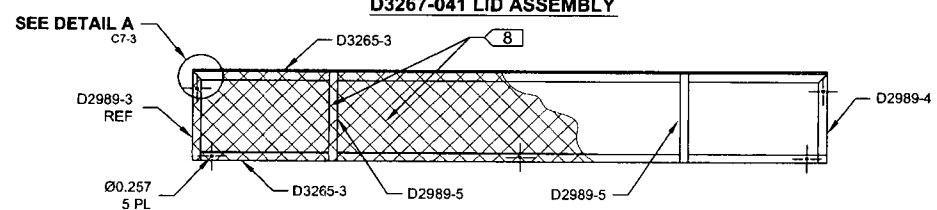
780

81566

375



D3267-041 LID ASSEMBLY



D3267-041 LID ASSEMBLY

C

- NOTES:**
- 1) MATERIAL: SEE SHEET 1
 - 2) FINISH: SEE SHEET 1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: N/A
 - 8) SKIN WITH EXPANDED STEEL MESH. TACK WELD MESH TO FRAME AT EVERY AVAILABLE LOCATION.
 - 9) REMOVE 2" x 6" SECTION OF MESH FROM BEHIND LABEL PLATE

RELEASED
08 07 04/17

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	AS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3267	2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
DATE	08.08.15	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

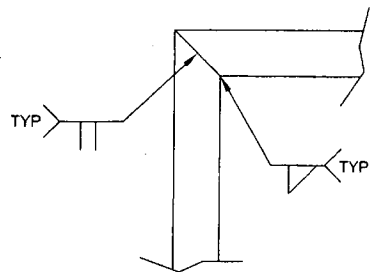
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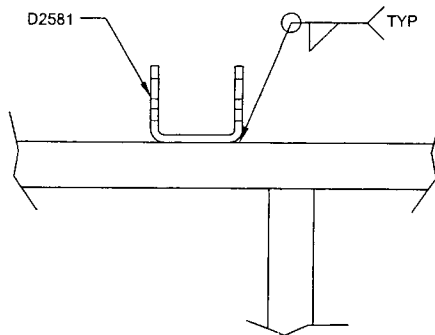
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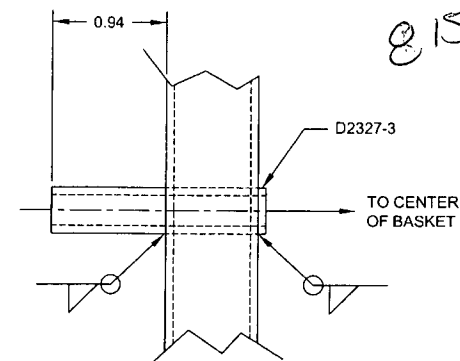
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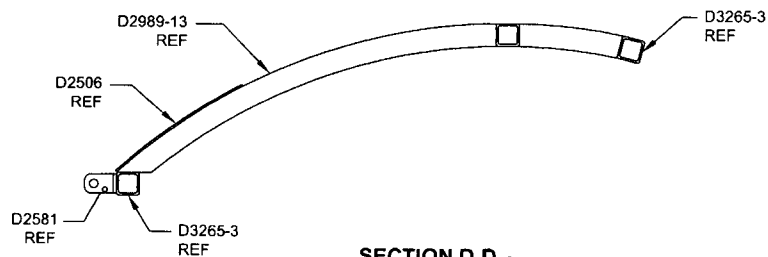
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JOINT WELD DETAIL TYP
SCALE 2X



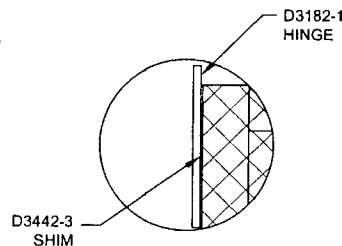
DETAIL B D2-2
2 PL
SCALE 2X



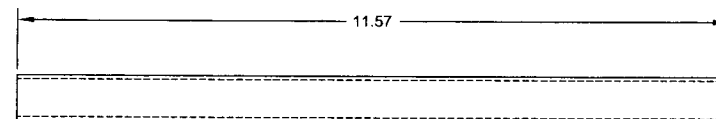
DETAIL C D5-2
SPACER INSTALLATION
SCALE 4X



SECTION D-D C4-2







DETAIL E B6-2
SCALE 2X
2 PL



D3267-1 STRUT
SCALE 2X

RELEASED
08-07-01/11/10

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	AUS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3267	3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSMBLY	NTS
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